

Date:
User:

Wednesday, 6/6/2007 1:47:55 PM

Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET ASSEMBLY
Job Number	: 32772	Part Number	: D2803041
Estimate Number	: 11029	Drawing Number	: D2803 REV B
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 6/6/2007 S.O. No. : N/A	Drawing Revision	: B
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A Type : PURCHASED PARTS	Due Date	: 6/30/2007
Previous Run	: 29391	Qty:	10 Um: Each
Written By	: <u>Kim Johnston</u>		
Checked & Approved By	: <u>Kim Johnston</u>		
Comment	: EST F 05.03.30 MS21043-3 was MS21042L3 KJ/JLM		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

D28031

STA 84 Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

STA 84 BRACKET

Pick:

Qty	Part Number	Description
1	D2803-1	Bracket

Batch

B32800 X10 ✓ ml

2.0

D28051

Stop



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

STOP

Pick:

Qty	Part Number	Description	Batch
1	D2805-1	Stop	B30819 X4 ✓

B30819 X4 ✓

~~B33600 X10 (X6)~~

B34073 (5) ml

3.0

D2809

Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Bushing

Pick:

Qty	Part Number	Description	Batch
1	D2809	Bushing	B34035 ✓

B34035 ✓

ml

4.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press D2805-1 into arm as per Dwg. D2803

mf 07-08-28 (10)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/08/29	5	split u/o	88	07/08/29	7	<i>[Signature]</i> 12/06/29	<i>[Signature]</i> 12/06/29

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/08/29
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/08/29	12	3 Arms D2803-041 were found with the hardware installed incorrect in the step location opposite of Qty. RC: Employee installed the hardware incorrectly. Human error.	<i>[Signature]</i> 12/06/29	Remove both nuts (MS21043) and bolts (ANCL316A) Reinstall LPS-3 Reinstall all hardware	<i>[Signature]</i> 07/08/29 <i>[Signature]</i> 07/08/29 <i>[Signature]</i> 07/08/29	<i>[Signature]</i> 07/08/29	<i>[Signature]</i> 12/06/29	<i>[Signature]</i> 12/06/29

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 32772

Part Number: D2803041

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press D2809 into arm as per Dwg D2803

9.0

AN3C16A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
2	AN3C16A	Bolt	

M102552

M101884

✓ ml

10.0

MS210433

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Nut

Pick:

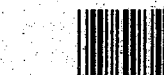
Qty	Part Number	Description	Batch
2	MS21043-3	Nut	M105211

✓ ml

11.0

NAS1515H3

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
4	NAS1515H3	Washer	M105164
A/R	LPS-3	Corrosion Spray	M104929

Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2803

✓ ml 07/08/29

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Job Number:



Seq. #:

Machine Or Operation:

Description:

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



x7

Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per Dwg D2803.

ml 07/08/29

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/08/29 (x7)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: GA

MF 07-08-30

15.0

QC21

FINAL INSPECTION/W/O RELEASE



7

Comment: FINAL INSPECTION/W/O RELEASE

07/08/31

Job Completion

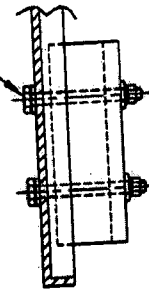


4 07-08-31

DART

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	REV. B
				D2803	SHEET 2 OF 2
DATE	04.11.22			TITLE	SCALE
				STA 84 BRACKET	1:3

AN3C16A BOLT (1)
NAS1515H3 WASHER (2)
MS21043-3 NUT (1)
INSTALL BOLT WITH LPS-3 CORROSION
INHIBITOR (ENSURE NO LPS-3 ON THREADS)
(2 PLACES)



SECTION D-D
SCALE 1:3
(ROTATED)

USE D2803-1 FOR D2803-041/-043
USE D2803-2 FOR D2803-042/-044

USE D2805-1 FOR D2803-041
USE D2805-2 FOR D2803-042
USE D2805-3 FOR D2803-043
USE D2805-4 FOR D2803-044
PRESS INTO PLACE PRIOR TO POWDER COAT

PRESS D2809 INTO PLACE
PRIOR TO POWDER COAT

SHOP COPY
RETURN TO
RELEASED
ENGINEERING
05-03-11
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
32772
NO

D2803-041/-043 BRACKET ASS'Y (SHOWN)
D2803-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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